

**DEPARTMENT OF TRANSPORTATION**

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch  
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 1.28**WELDING INSPECTION REPORT****Resident Engineer:** Casey, William**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-027751**Date Inspected:** 12-Jun-2012**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1730**Contractor:** American Bridge/Fluor Enterprises, a JV**Location:** Job Site**CWI Name:** As noted below.**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** Tower Component**Summary of Items Observed:**

Quality Assurance Inspector (QA) William Clifford was at the American Bridge/Fluor (ABF) job site at Yerba Buena Island in California between the times noted above in order to monitor Quality Control functions and the in process work being performed by ABF personnel. The following items were observed:

**Electroslag Weld Excavation**

Excavation began approximately 9:30am.

This QA observed ABF/JV welding personnel Xiao Jian Wan #9677 excavation of an Electroslag Weld (ESW) previously Ultrasonic Tested (UT) by Quality Control (QC) technicians.

The UT discovered indications were found to be oriented in the longitudinal position. The indications were found to range from rejectable per AWS D1.5 Table 6.4 to within the recordable criteria to be subject to further Radiographic Testing (RT).

The weld being excavated is designated as "ESW E" and was excavated at multiple locations throughout the "Y=4140mm" to 9m elevation. These excavations are ongoing and have yet to receive final measurements for depth, width, and length.

The carbon arc gouging process, as well as machine grinding, were used to excavated approximately 2mm-5mm at a time. In between excavation passes both QA and QC performed Magnetic Particle Testing (MT) and photographed any discovered indications.

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## WELDING INSPECTION REPORT

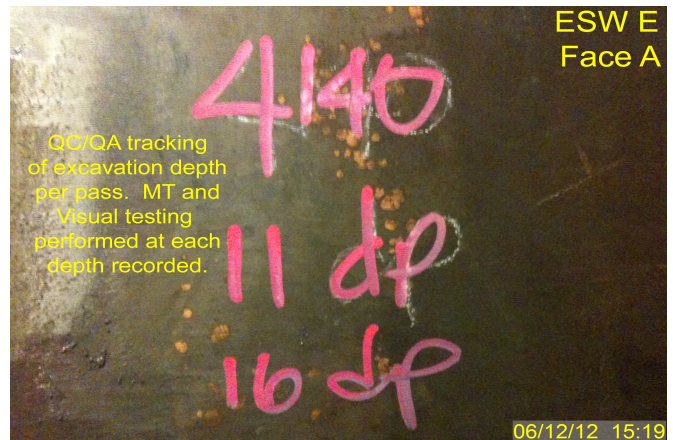
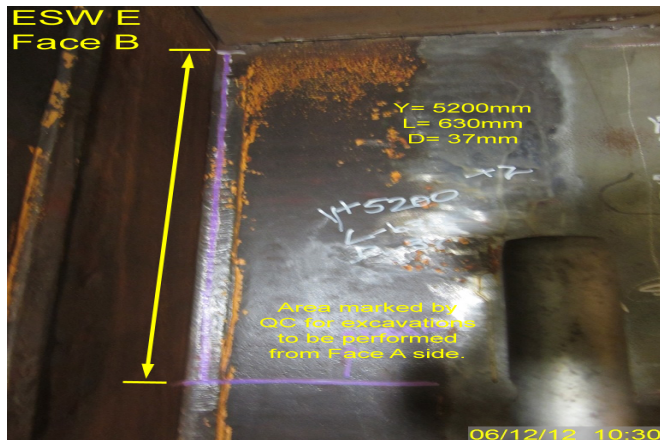
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At this time of excavation this QA has not observed any indications using either MT or visual testing methods.

QC MT and data recording was performed by Jesse Cayabyab and Bernie Docena

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.



### Summary of Conversations:

Conversations were relevant to testing performed and indications discovered during excavation.

### Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact SMR Nina Choy (510) 385-5910, who represents the Office of Structural Materials for your project.

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<b>Inspected By:</b>	Clifford, William	Quality Assurance Inspector
<b>Reviewed By:</b>	Levell, Bill	QA Reviewer

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